

Split

ship Oct 20

Work Order ID 150846-2

150846

Page 1

Thursday, September 08, 2016 10:01:19 AM

Item ID: D4092-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Maintenance Step Assembly
 Start Date: 9/8/2016 Start Qty: ~~6.00~~ *6* Cust Item ID:
 Required Date: 10/19/2016 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: Sam Date: 16/09/08 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4092	C								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.38							
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.02							
Quality Control									

SEP 08 2016

DAS
36
9-89

16/09/23

DAS
38
9-89

SEP 23 2016

Work Order ID 150846***150846***

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Thursday, September 08, 2016 10:01:19 AM

Item ID: D4092-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Maintenance Step Assembly

Start Date: 9/8/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>SK</u>	0.00							
130									
Packaging	Memo	0.01							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

SEP 26 2016

DAS
21
9-89

16/9/26

DAS
21
9-89

SEP 26 2016

Picklist Print

Page 1

Thursday, September 08, 2016 10:01:19 AM

Work Order ID: 150846

150846

Parent Item: D4092-041

D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 9/8/2016

Required Date: 10/19/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD IPP
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1		Manufactured	No			100	Each	25.0000	2	12			

D4092-1

Maintenance Step

Location	Loc Qty	Loc Code
ST450	25	
141433	1	
144611	16	
150169	8	

D4093-1		Manufactured	No			100	Each	12.0000	1	6			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4093-1

Bracket

Location	Loc Qty	Loc Code
ST449	12	
142175	12	

D4093-3		Manufactured	No			100	Each	5.0000	1	6			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4093-3

Bracket

Location	Loc Qty	Loc Code
ST449	5	
141786	1	
142841	4	

SEP 09 2016

B150853 DAS
36
9-89
(1X)

Picklist Print

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Thursday, September 08, 2016 10:01:19 AM

Work Order ID: 150846

150846

Parent Item: D4092-041

D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 9/8/2016

Required Date: 10/19/2016

Start Qty: 6.00

Required Qty: 6.00

D4093-5

Manufactured No

100 Each

10.0000 2 12

D4093-5

Bracket

**

2x 150/60 DAS 6 9-89 2016/9/14

Location

Loc Qty

Loc Code

ST078

10

141426

2

142819

8

MS24694-S54

Purchased No

100 Each

84.0000 2 12

MS24694-S54

SCREW

**

Location

Loc Qty

Loc Code

over006

50

m134851

50

ST284

34

m135274

34

MS24694-S55

Purchased No

100 Each

195.0000 8 48

MS24694-S55

Screw

**

Location

Loc Qty

Loc Code

ST283

195

m134376

95

m135408

100

MS24694-S56

Purchased No

100 Each

40.0000 2 12

MS24694-S56

SCREW

**

Location

Loc Qty

Loc Code

ST283

40

m132344

40

DAS 6 9-89 SEP 09 2016

Thursday, September 08, 2016 10:01:19 AM

Shop Packet Print

Page 2

Picklist Print

Page 3

Thursday, September 08, 2016 10:01:19 AM

Work Order ID: 150846

150846

Parent Item: D4092-041

D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 9/8/2016

Required Date: 10/19/2016

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0332J

Purchased

No

100

Each

1,494.000

12

72

NAS1149D0332J

Washer

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

506

m134848

506

ST260a

600

m135566

600

ST264

382

m135536

382

72

MS21042L3

Purchased

No

100

Each

1,649.000

12

72

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

14

m133790

14

GA

278

m134360

112

m135135

166

OVER007

600

m135530

600

ST303

757

m135135

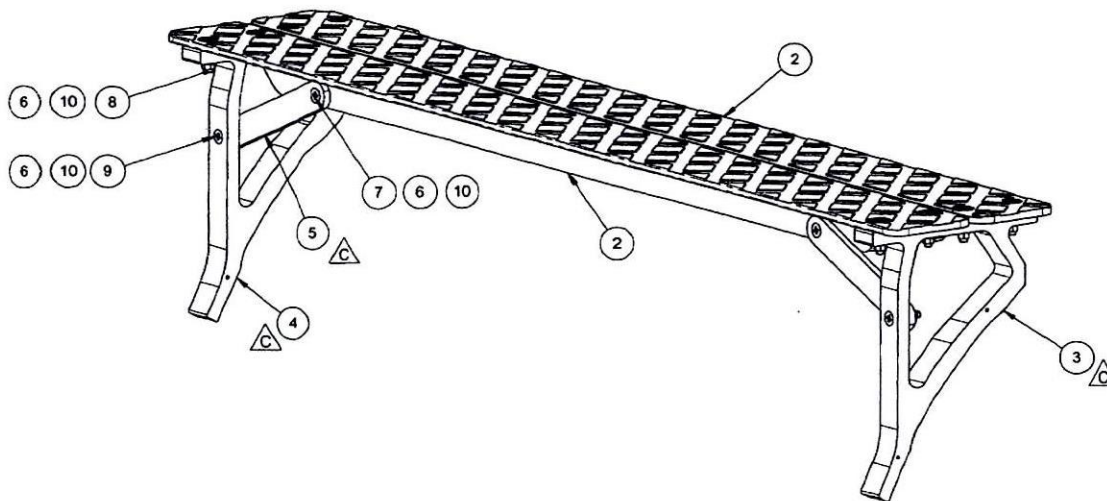
157

m135407

600

72

SEP 09 2016



D4092-041 MAINTENANCE STEP ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT, SELF-LOCKING
7	2	MS24694-S54	SCREW, CSK 100°
8	8	MS24694-S55	SCREW, CSK 100°
9	2	MS24694-S56	SCREW, CSK 100°
10	12	NAS1149D0332J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150846

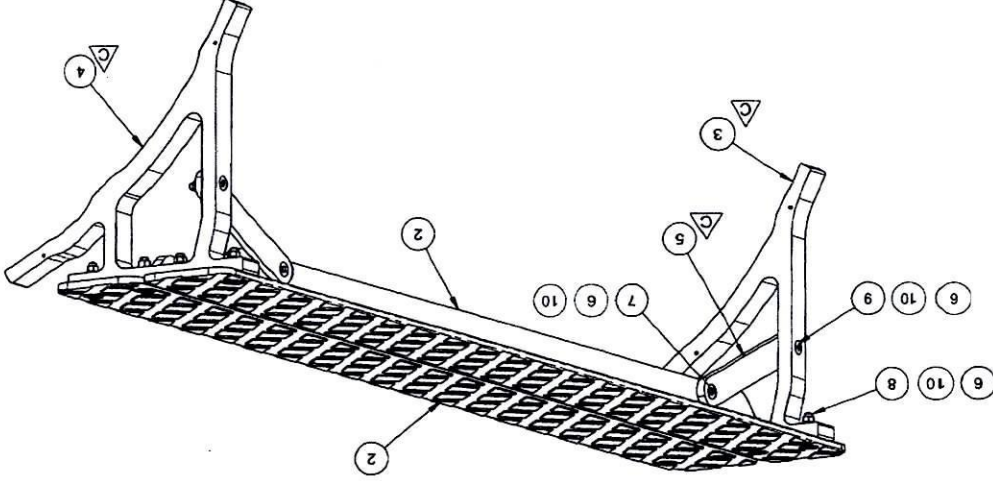
dm 16/09/08

RELEASED
2015-09-21
ECN 15-556

C	REVISE DIMENSION; ZN D5-5, D8-5, B3-6, ADD BALLOONS; ZN B3-1, C6-1, B7-1, C6-2, B6-2, B4-2	VS	15.03.09
B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4092 REV. C SHEET 1 OF 6 TITLE MAINTENANCE STEP ASSY SCALE NTS COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DRAWN	VS		
CHECKED	RF		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS	DATE 15.03.09	

APPROVED

ITEM	QTY	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT, SELF-LOCKING
7	2	MS24694-S54	SCREW, CSK 100"
8	8	MS24694-S55	SCREW, CSK 100"
9	2	MS24694-S56	SCREW, CSK 100"
10	12	NAS1149D0332J	WASHER

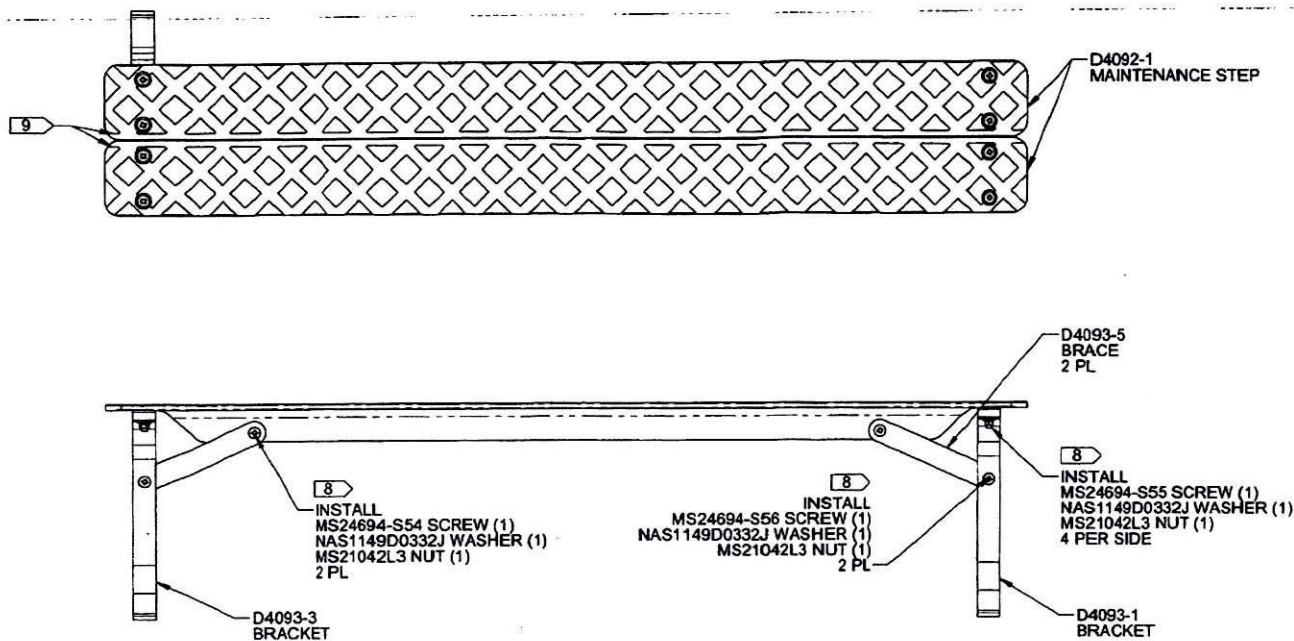


D4092-042 MAINTENANCE STEP ASSEMBLY

DESIGN		VS	VS	DART AEROSPACE USA, INC.
DRAWN		VS	VS	KENT, WA
CHECKED		RF	RF	REV. C
MFG. APPR.		JLM	JLM	SHEET 2 OF 6
APPROVED		HS	HS	SCALE
DE APPR.		DS	DS	MAINTENANCE STEP ASSY
DATE		15.03.09		NTS

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RELEASED
2015-09-21



D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.28 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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2015-09-21

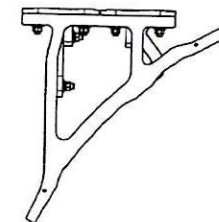
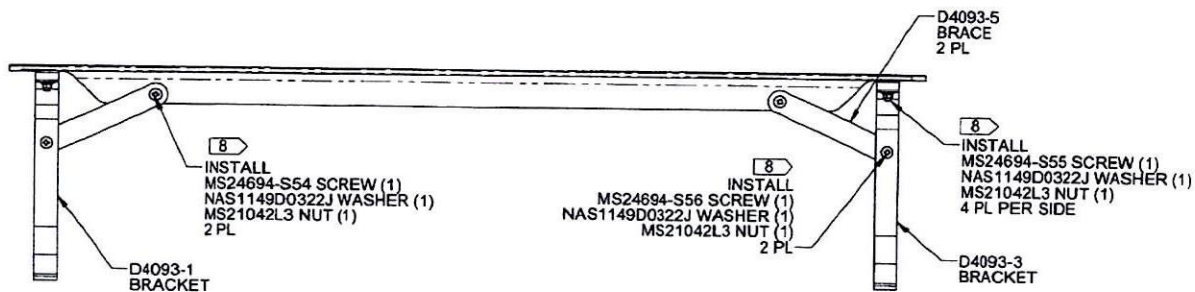
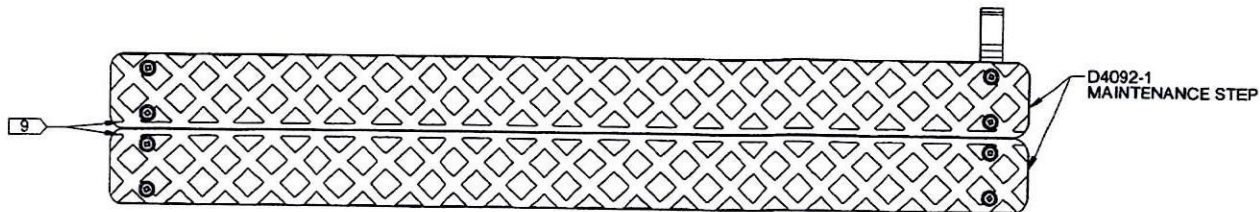
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DESIGN	VS
DRAWN	VS
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MFG. APPR.	JLM
APPROVED	HS
DE APPR.	DS
DATE	15.03.09

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.	REV. C
D4092	SHEET 3 OF 6
TITLE	SCALE
MAINTENANCE STEP ASS'Y	NTS

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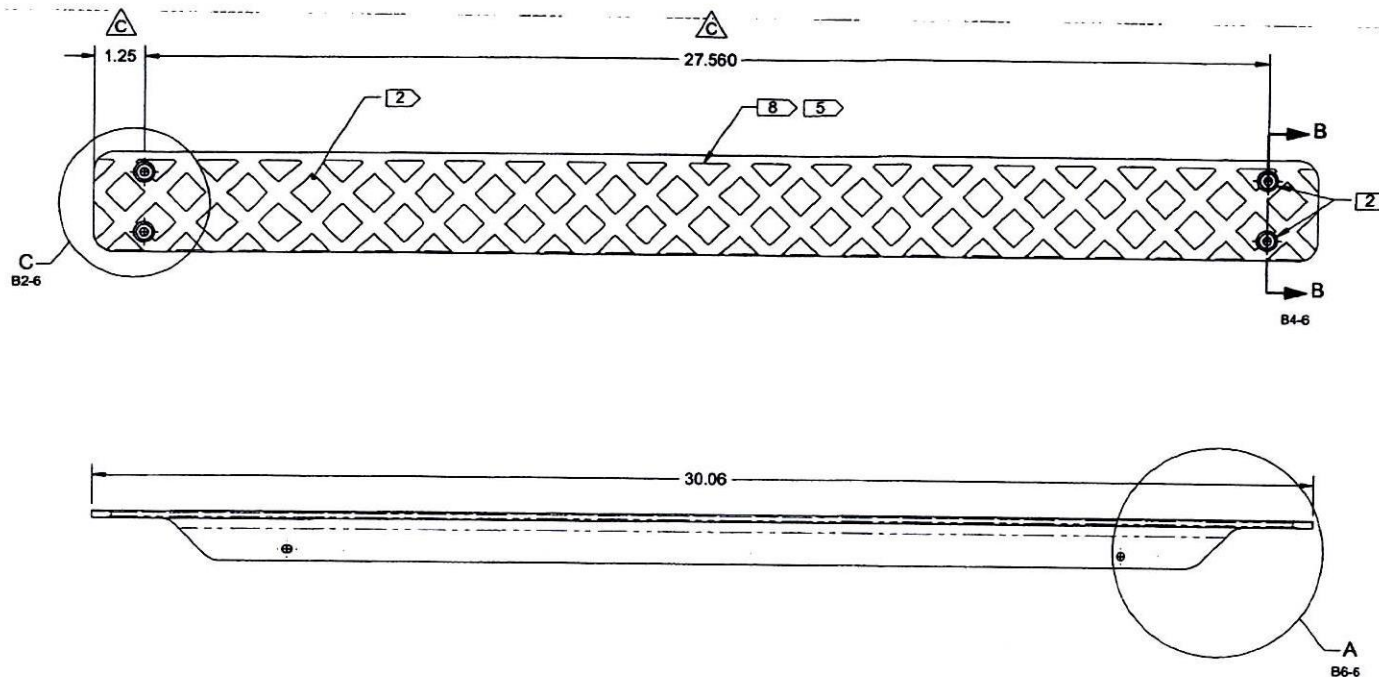
D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.28 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

RELEASED
2015-09-21

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	DRAWN	VS			
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	APPROVED	HS			
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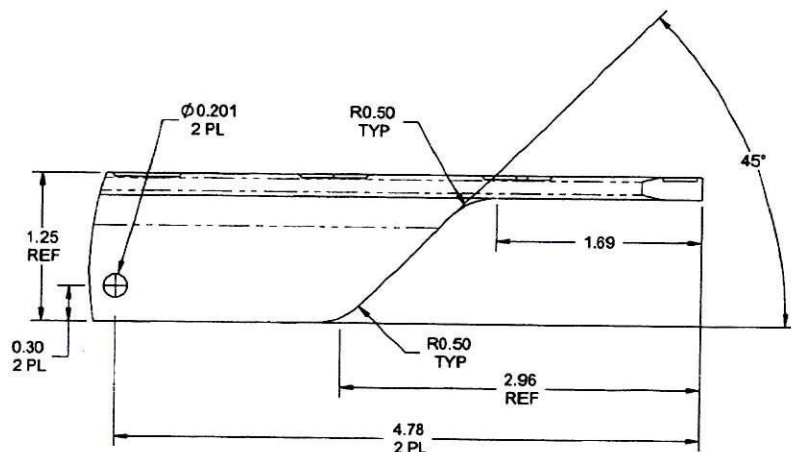
D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

NOTES:

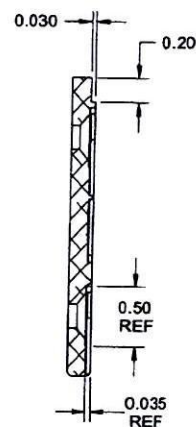
- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

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2015-09-21

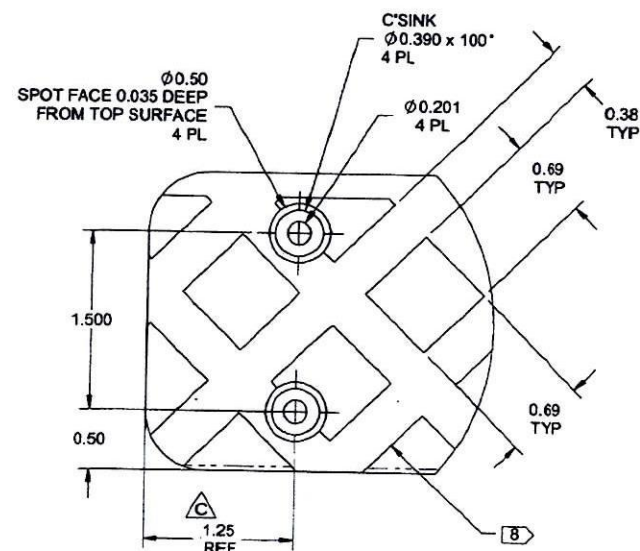
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	APPROVED	HS	
DE APPR.	DS		
DATE	15.03.09		



DETAIL A
SCALE 3X, TYP B3-5



SECTION B-B
SCALE 3X, TYP C3-5



DETAIL C
SCALE 3X, TYP C8-5

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2015-09-21

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	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D4092	SHEET 6 OF 6
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DE APPR.	DS	MAINTENANCE STEP ASS'Y	NTS	
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